

Work Order ID 52593

October 2, 2009 11:20:25 AM



Page 1

Item ID: D3564-9

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 02/10/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-2*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

MAY NOT PULL

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: *D* ☐ Prog
Rev: *D* ☐ 2-Deburr if necessary

B9-10-19

(22)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B9-10-19

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) 509/10/19

counters
(22)

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Page 2

Item ID: D3564-9

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearshoe

Start Date: 02/10/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 20/10/2009 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157

8/09/10/20

22

2

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

2) 8/01/10/20

center
+22

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
M112920 Weld hardcoat as per Dwg D3564

EL

9-10-22

222

Work Order ID 52593

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Page 3

Item ID:	D3564-9	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Wearshoe					
Start Date:	02/10/2009	Start Qty: 16.00		Cust Item ID:		
Required Date:	20/10/2009	Req'd Qty: 16.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	27 Serlutz			(x28)	4		
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27 Serlutz			count (x22)	4		
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M109091 Memo START TIME: 11:30am 12:00pm FINISH TIME: _____	0.00 0.00	M 09/10/26			(x22)	8		

Work Order ID 52593

October 2, 2009 11:20:25 AM



Page 4

Item ID:	D3564-9	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Wearshoe					
Start Date:	02/10/2009	Start Qty: 16.00		Cust Item ID:		
Required Date:	20/10/2009	Req'd Qty: 16.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							
200 	Identify as per dwg & Stock Location: <u>FP-19</u>	0.00							
Packaging Packaging	Memo	0.00							
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

MO 09/10/26 X22

09/10/26 (X22) 0

09-10-28

09-10-27

Picklist Print

October 2, 2009 11:20:25 AM

Work Order ID: 52593



Parent Item: D3564-9RevD



Parent Item Name: Wearshoe



Start Date: 02/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	133.4426	18.5263	26.000		
												13910-19
304/316 Sheet .063												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	133.4425737	
106860	16.018	
111924	25.1689737	
112442	59.4926	
112567	32.763	
112290		

112290

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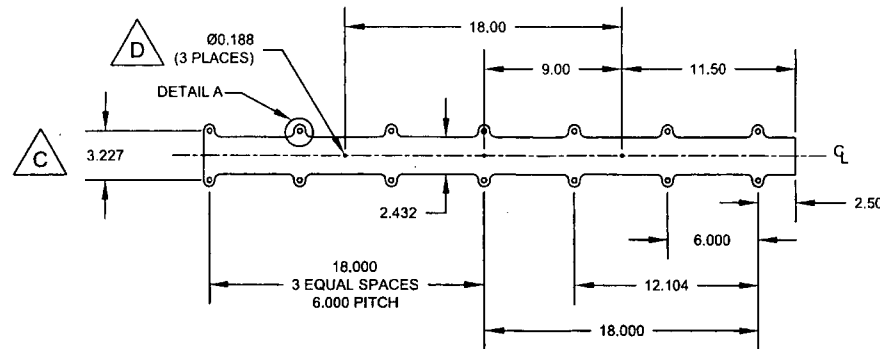
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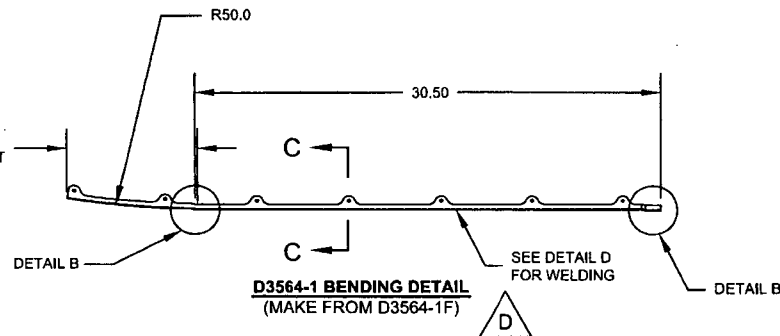
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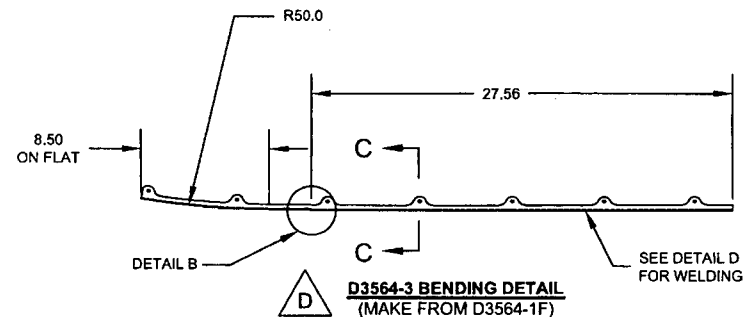
D3564-1F FLAT PATTERN



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

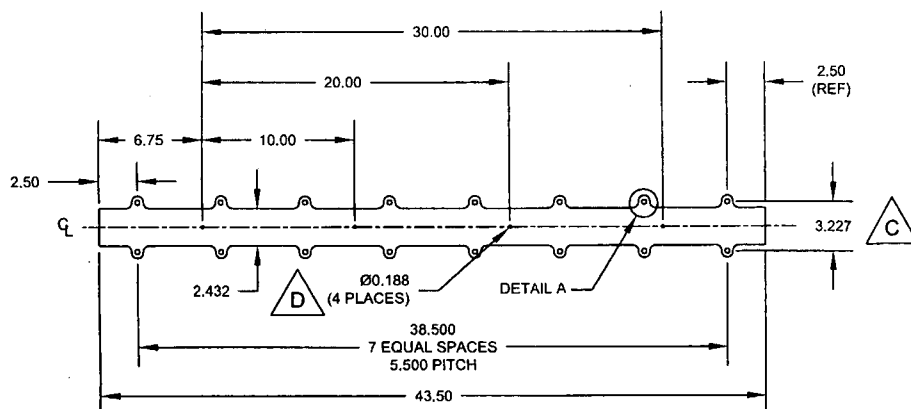
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

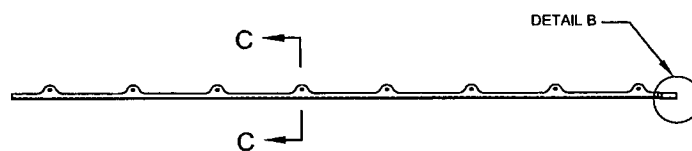
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i> <i>CB</i> <i>PH</i> <i>PH</i> <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D3564	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		WEARSHOE	1:8
DE APPR.			
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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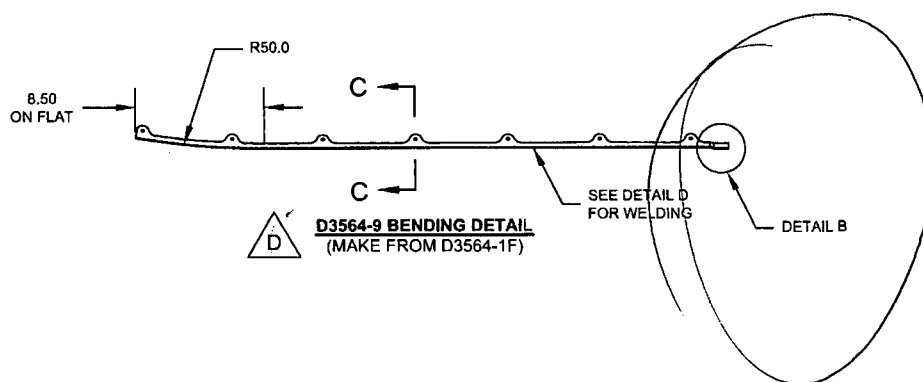
WORK ORDER
 NO. 52593



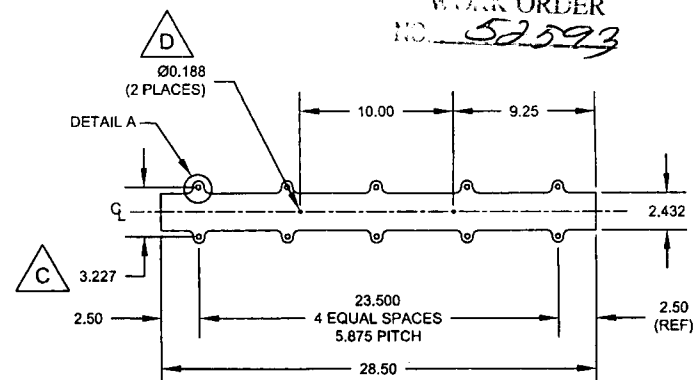
D3564-5F FLAT PATTERN



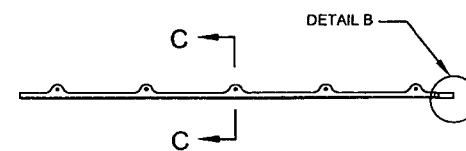
D3564-5 BENDING DETAIL
 (MAKE D3564-5 FROM D3564-5F)



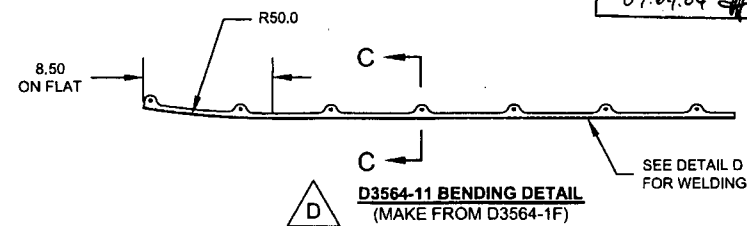
D3564-9 BENDING DETAIL
 (MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
 (MAKE D3564-7 FROM D3564-7F)

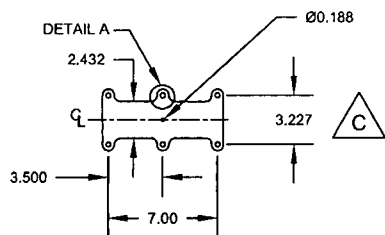


D3564-11 BENDING DETAIL
 (MAKE FROM D3564-1F)

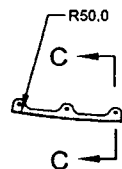
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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
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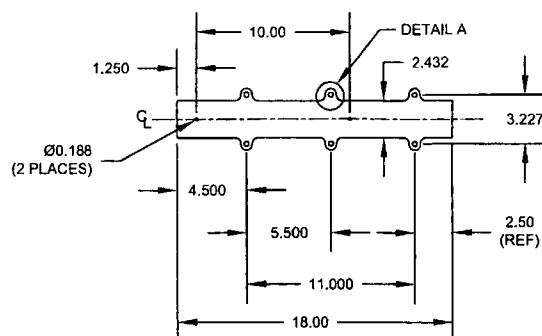
8 7 6 5 4 3 2 1



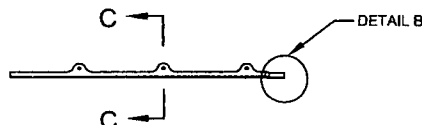
D3564-13F FLAT PATTERN



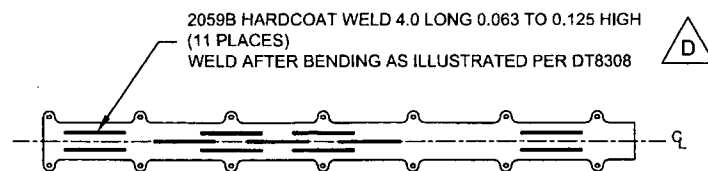
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

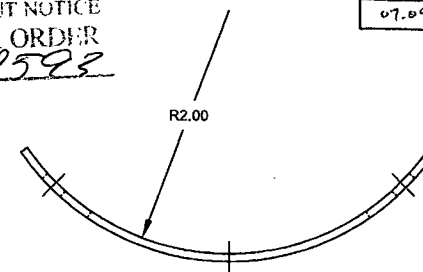


DETAIL D
(D3564-1/3/9/11 WELDING DETAIL)

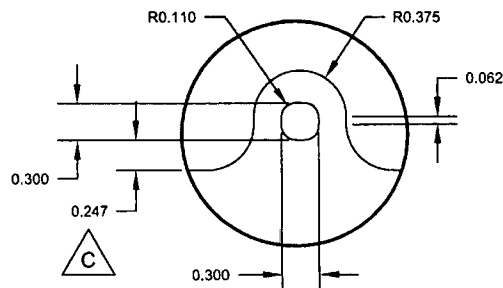
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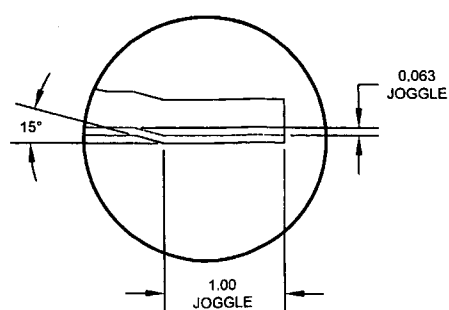
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SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
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8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	52593
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.228	x			
2.432	+/-0.010	2.431	x			
2.50	+/-0.030	2.500	x			
6.000	+/-0.010	6.000	x			
12.104	+/-0.010	12.104	x			
18.000	+/-0.010	18.00	x			
18.000	+/-0.010	18.00	x			
18.00	+/-0.030	18.00	x			
9.00	+/-0.030	9.00	x			
11.50	+/-0.030	11.50	x			
0.300 x 0.300	+/-0.010	301 x 303	x			
Ø0.188	+0.005/-0.001	.191	x			
R0.375	+/-0.010	.375	x			
0.063	+/-0.010	.060	x			

Measured by:	EB	Audited by:	S	Prototype Approval:	N/A
Date:	9-10-19	Date:	09/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	